

**ABSTRACT**

The caster roll (10) is used in the manufacture of metal plate, strip, sheet, or foil. The caster roll (10) includes a cylindrical roll core (12) and at least one metal overlay (14) formed on the roll core (12). The at least one metal overlay (14) defines a plurality of cooling passages (34) for conducting a cooling medium through the at least one metal overlay (14) to cool the roll (10) during use. Additional metal overlays (16) may be formed on top of the at least one metal overlay (14). The cooling passages (34) may also be formed in the roll core (12).